

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014766**Date Inspected:** 07-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056364 perform SMAW Buttering welding on; North shaft, Lift 5 in the cut edges and the weld joint identified as NSD1-STSA5-3B-F-40A. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-2G (2F)-Repair.(Photo attached)

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 050289 perform SMAW welding on; Lift 4 to 5, interior splice plate and the weld joint is identified as SSD1-SPSA5-16-3B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053869 perform FCAW welding on; Lift 4 Façade plate and the weld joint is identified as SD1-STSA4-49A/B- 6, 8. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

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Bay no. 11

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769 perform SMAW welding on; Spare strut Flange to stiffener and the weld joint is identified as ND1-STSA4-6-10-119 mtr.-1-49, 50. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112.

Tower Jetty

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040690 perform SMAW welding on; 65 mtr. elevation, Cross bracing connection plate to the West Shaft, Lift 2 Doubler plate and the weld joint identified as WSD1-SA 340 B/F-15. ZPMC CWI Identified as Mr. Qiu Wen. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4213-TC-U4C-1. (Photo attached)

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as Tower Spare strut at Bay no. 11. The weld designations reviewed are as follows:

ND1-STSA4-6-123 mtr.-2 – Jt. nos – 73A,74A,9B,10B,9A,10A,5B,6B –Spare strut

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan
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Quality Assurance Inspector

Reviewed By:	Clifford,William
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QA Reviewer
